

Work Order ID 75842

75842

Page 1

Friday, November 18, 2011 10:26:58 AM

Item ID: K10111 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, Skidtube 206
 Start Date: 11/1/2011 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 11/11/2011 Req'd Qty: 4.00 *4* Customer:

Reference:

Approvals: Process Plan: Date: 11/1-18 Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
DSI 9583	A	
K10111	B	<u>SP</u>

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP FOR D206-642-111 CHG007 FOR D206-642-113 CHG002	K10111 CHG003							

SP 12-2-9 (4)

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

SP 12-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75842***75842***

Page 2

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Item ID: K10111 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Skidtube 206
Start Date: 11/1/2011 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/11/2011 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		51262/10		(44)			
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP PPP D206-642-111 PPP D206-642-113 Location: _____ PPP rev: <u>f</u>	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

12/2/13

12-02-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

Friday, November 18, 2011 10:27:03 AM

Page 1

Work Order ID: 75842

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: F01.11.08 Revised Step 5 and Added Inspection Level
21SM IPP REV:G
11.09.23 PER REV.B DD VERF:EC IPP REV:H 11.11.14
AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN5-10A		Purchased	No				Each	872.0000		16			
AN5-10A									**	SP.			
Bolt													

Location	Loc Qty	Loc Code
ST337	872	
116704	11	
118191	59	
119547	802	

AN5-11A		Purchased	No				Each	1,599.000		16			
AN5-11A									**	SP.			
Bolt													

Location	Loc Qty	Loc Code
ST337	21	
117313	2	
118191	19	
ST518	1578	
119512	1578	

AN3-41A		Purchased	No			110	Each	1,655.000	1	8	32		
AN3-41A									**	SP 12-02-09.			
Bolt													

Location	Loc Qty	Loc Code
st510	1655	
119042	1655	

32X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Work Order ID: 75842

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-6A Purchased No 110 Each 5,062.000 12 48

AN4-6A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST356

62

119127

62

ST516

5000

119017

5000

110 Each 489.0000

1 4

**

48x

SP

AN4C5A

AN4C5A

BOLT

Location

Loc Qty

Loc Code

FP-B

49

112243

49

ST355

440

112243

340

119017

100

110 Each 511.0000

2 8

**

SP

AN6-44A

AN6-44A

Bolt

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

504

119036

504

110 Each 1.0000

1

**

8x

B77866 SP

D206-651-041 CH6701

D206-651-041

206A/B GHW

Location

Loc Qty

Loc Code

FG125

1

74002

1

12-02-09

Friday, November 18, 2011 10:27:03 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

D2652 Manufactured No

110 Each

743.0000

16

64

D2652

Bushing

**

B77135 SP.

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

699

73835

579

73836

120

D2661-1

Manufactured No

110 Each

18.0000

2

8

D2661-1

Saddle, LH Fwd Aft Out 206

**

B78135 SP.

Location

Loc Qty

Loc Code

MEZZ

5

64559

5

ST435

13

73838

10

73841

1

76516

2

D2662-1

Manufactured No

110 Each

20.0000

2

8

D2662-1

Saddle, LH In 206

**

B78150 SP.

12-02-09.

Location

Loc Qty

Loc Code

ST435

10

73846

1

74479

9

ST476

10

74481

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

D2712 Manufactured No

110 Each 2,551.000 10 40

D2712

Set Screw

**

SP

Location

Loc Qty

Loc Code

FG 50

29962 50

ST021 2501

71160 1

73837 500

76065 2000

D2884 Manufactured No

110 Each 100.0000 2 8

D2884

Saddle Spacer

**

B76751 SP

Location

Loc Qty

Loc Code

FG 10

29453 10

ST025 90

73823 90

D2885 Manufactured No

110 Each 126.0000 1 2 8

D2885

Saddle Spacer

**

B76752 SP
12-02-09

Location

Loc Qty

Loc Code

FG 10

29199 10

ST025 116

73824 116

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

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75842

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3413-1

Manufactured No

110

Each

94.0000

1

4

D3413-1

Ring

**

B76754 SP

Location

Loc Qty

Loc Code

ST368

2

73821

2

ST420

2

66387

1

70773

1

ST469

88

73822

88

ST473

2

71041

2

MS21042L3

Purchased

No

110

Each

8,753.000

8

32

MS21042L3

Nut

**

SP- 12-02-09.

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2498

119075

2498

32A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 6

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Work Order ID: 75842

75842

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

110

Each

11,450.00

12

48

MS21042L 4

Nut

**

SP

Location

Loc Qty

Loc Code

ST300

558

117441

51

117601

374

118451

133

ST516

5892

119017

5892

ST518

5000

119075

5000

48x

MS21042L6

Purchased

No

110

Each

1,484.000

2

8

MS21042L 6

Nut

**

SP

Location

Loc Qty

Loc Code

ST300

484

117677

25

118384

5

118927

48

118968

406

ST518

1000

119075

1000

8x

NAS1149C0463R

Purchased

No

110

Each

1,379.000

1

4

NAS1149C0463R

Washer

**

SP12-02-09

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1378

117735

378

119097

1000

4x

Friday, November 18, 2011 10:27:03 AM

Shop Packet Print

Page 6

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 7

Friday, November 18, 2011 10:27:03 AM

Work Order ID: 75842

75842

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

110

Each

4,434.000

8

32

NAS1149D0363.I

Washer

**

~~11/30/12~~ SP.
m120308 32x.

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1418

117601

148

118077

1

118612

55

118968

1214

NAS1149D0463J

Purchased

No

110

Each

12,582.00

24

96

NAS1149D0463.I

Washer

**

SP

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12258

119075

10000

119097

2258

26x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 8

Friday, November 18, 2011 10:27:03 AM

Work Order ID: 75842

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

110

Each

5,121.000

8

32

NAS1149D0563.I

**

SP

Washer

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3121

118206

2121

118614

1000

32x

NAS1149D0663J

Purchased

No

110

Each

2,598.000

4

16

NAS1149D0663.I

**

SP 12-02-09

Washer

Location

Loc Qty

Loc Code

ST407

2598

119075

2598

16x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	K10111	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE KIT	NTS
DATE	11.11.10	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	